

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Work Order ID 140674

140674

January 13, 2016 1:08:08 PM

Item ID: D4095-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Aft
 Start Date: 1/13/2016 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 1/27/2016 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE				DAS				
Brake NC		0.01			30	8			JAN 27 2016
Brake NC	Memo				9-89				
	1- bend section C-C first								
	2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155								
	3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC		0.00				8			DAS
Quality Control	Memo								38
	Ensure joggle as per dwg D4095								9-89
									JAN 27 2016
									P.T.O.
150		0.00							
150	Weld per dwg & QSI004 4.5								
autoweld 1	Large Fab								
Automated Welding 1	Memo	0.00							
	SEE NOTE 10 FOR SURFACE BUILDUP								
	1- WELD AS PER DWG AND QSI004 4.5								
	FOR AUTOMATED WELDING USE 8259 HARDCOAT								
	BATCH: <u>1133209</u>								

8
 8
 7 V/X/EL 16-2-1

DQA: Aut Date: 16.05.01

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: RAU Date: 16/02/29Work Order update only ☐

Work Order: <u>140674</u> Part No. <u>D4095-043</u> NCR No. <u>16-5636</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☒</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☒	Composite ☐	Supplier ☐																																																
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Date: <u>16-01-28</u>	Step #: <u>150</u>	QTY Effective: <u>1</u>	MRB (QSI042) Approval DAS 9 9-89 <u>16-02-24</u>																																																																
Description Work Order Deviation Machine error try fixing program wire got jammed up in machine (robot welder) RC. Process improvement RC. process		Disposition Scrap / destroy no replace																																																																	
		Completed By <u>38</u> JAN 28 2016 Lead hand / Supervisor Approval Verification <u>16-01-28</u>																																																																	
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Work Order ID 140674***140674***

Page 3

Item ID: D4095-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Wearplate Aft

Stop ***NS2***

Start Date: 1/13/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/27/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC10- Inspect visual per QSI004- ground welds	0.00							
160						(7)			DAS 38 9-89
QC	Memo	0.00							FEB 01 2016
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							
170						(7)			DAS 38 9-89
QC	Memo	0.00							FEB 01 2016
Quality Control									
180		0.00							
180						7			DAS 41 9-89
HandFinish	Memo	0.01							16-2-1
Hand Finishing	COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: <u>133808</u>								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

January 13, 2016 1:08:08 PM

Page 4

Stop *NR2*

[illegible]

200	Identify as per dwg & Stock Location: <u>FP-002</u>	0.00
200		
Packaging	Memo	0.00
Packaging	LOCATION : FP002	

210	QC21- Final Inspection - Work Order Release	0.00
210		
QC	Memo	0.01
Quality Control		

ML5 FEB 02 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

January 13, 2016 1:08:12 PM

Page 1

Work Order ID: 140674

140674

Parent Item: D4095-043

D4095-043

Parent Item Name: Wearplate Aft

Start Date: 1/13/2016

Required Date: 1/27/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC
15.10.29 AUTOMATED WELDING DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased			No	100	sf	162.4500	2.275	19.15789			

M304S16GA

304/316 Sheet .063

01/16/2016

Location

Loc Qty

Loc Code

MAT019

162.45

m132797

2.45

m133511

160

13.3

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD

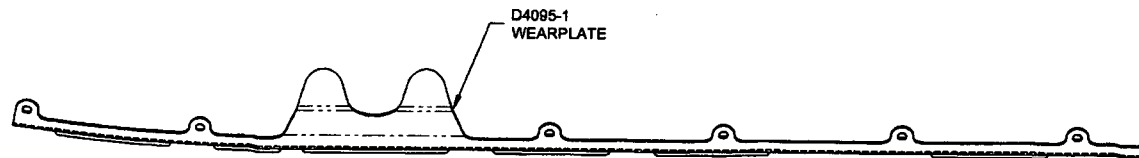
D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT CENTERLINE

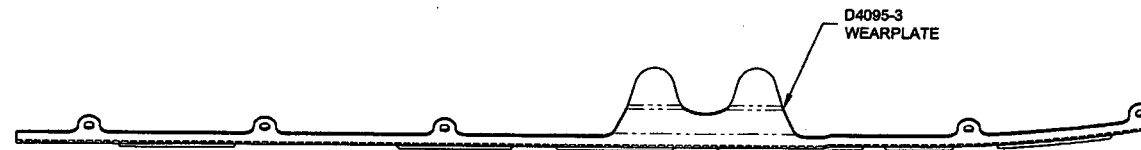
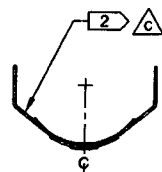
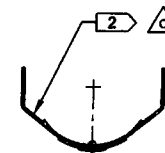
20160113 SH 140674

C	8259 WELD ROD WAS 2058B, 0.20 WELD THICKNESS WAS 0.25, MOVE DRAIN HOLE IN -1/-3, 0.9 WAS 2.00 (TYPO B4-9), ADJUST TOL. FOR MANUFACTURABILITY, NOTE 2 NOW REF'S QSI 005 4.9, UPDATE MAT'L SPEC	CP	16.01.06
B	REVISED D4095-1/-1F/3/3F: 4715 PLUS ONE ROCK-GUARD REPLACES D4096-1/-3; ADDED D4095-5/-7 -9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC	
DRAWN		EUGENE, OR	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4095	SHEET 1 OF 9
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	16.01.06	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2016-01-11
EUN 16-504



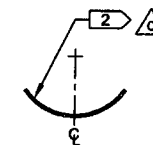
D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY

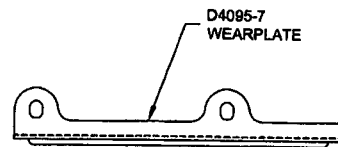


D4095-045 WEARPLATE ASSEMBLY

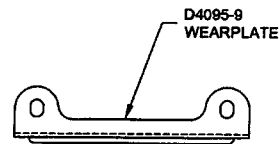
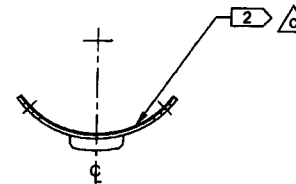


RELEASED
2016-01-11

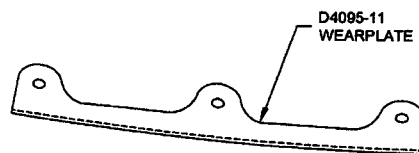
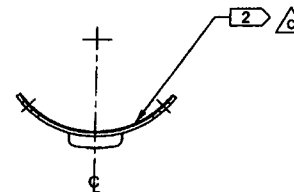
DESIGN		DART AEROSPACE USA, INC	
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MFG. APPR.		D4095	SHEET 2 OF 9
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DE APPR.		WEARPLATE	NTS
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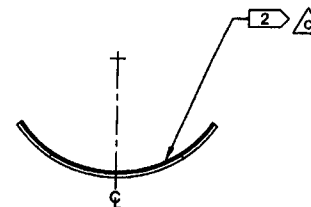
D4095-047 WEAR PAD ASSEMBLY



D4095-049 WEAR PAD ASSEMBLY



D4095-051 WEARPAD ASSEMBLY



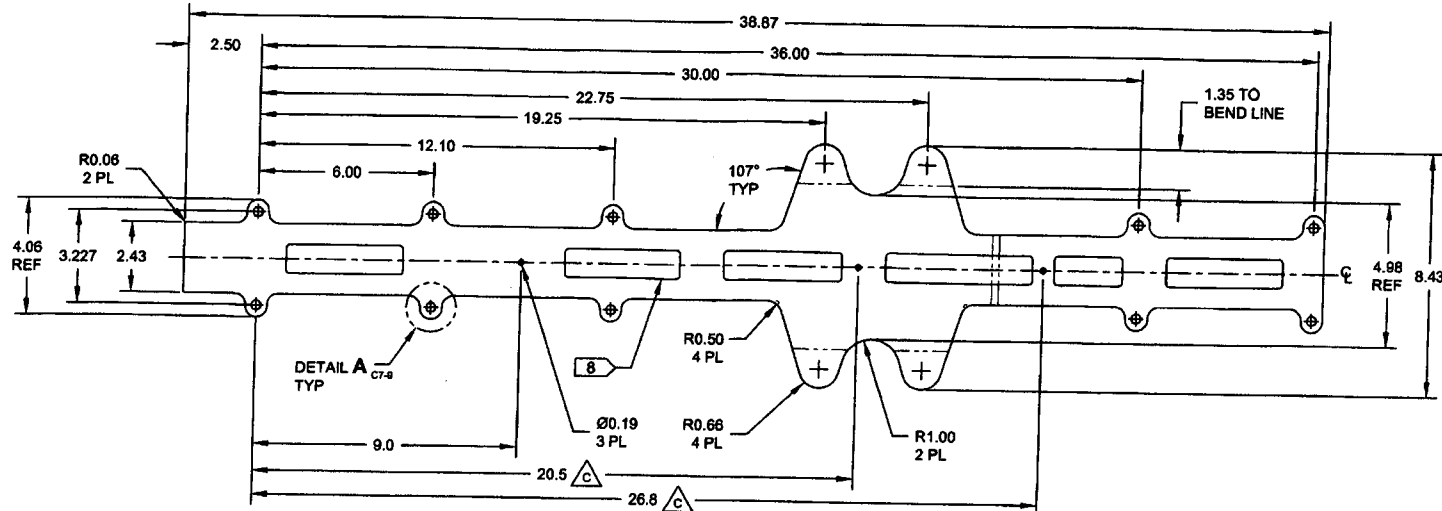
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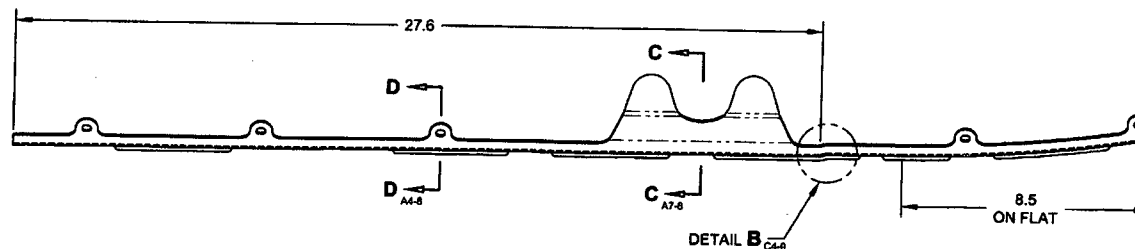


9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

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D4095-3F FLAT PATTERN 1



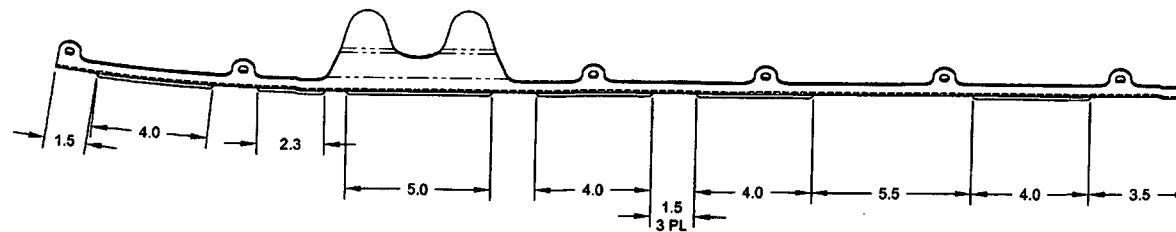
D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

D4095-3 NOTES:

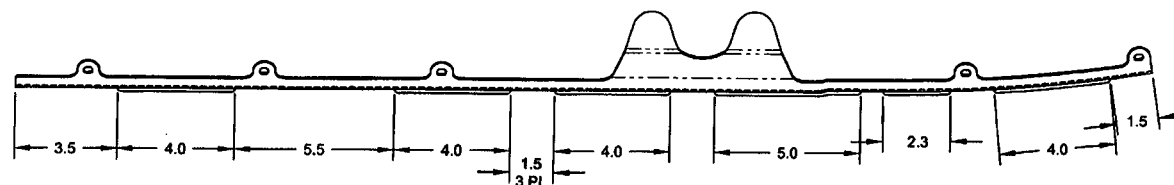
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240
OR ASME SA240 REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5
- 9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

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D4095-1 WELDING DETAIL

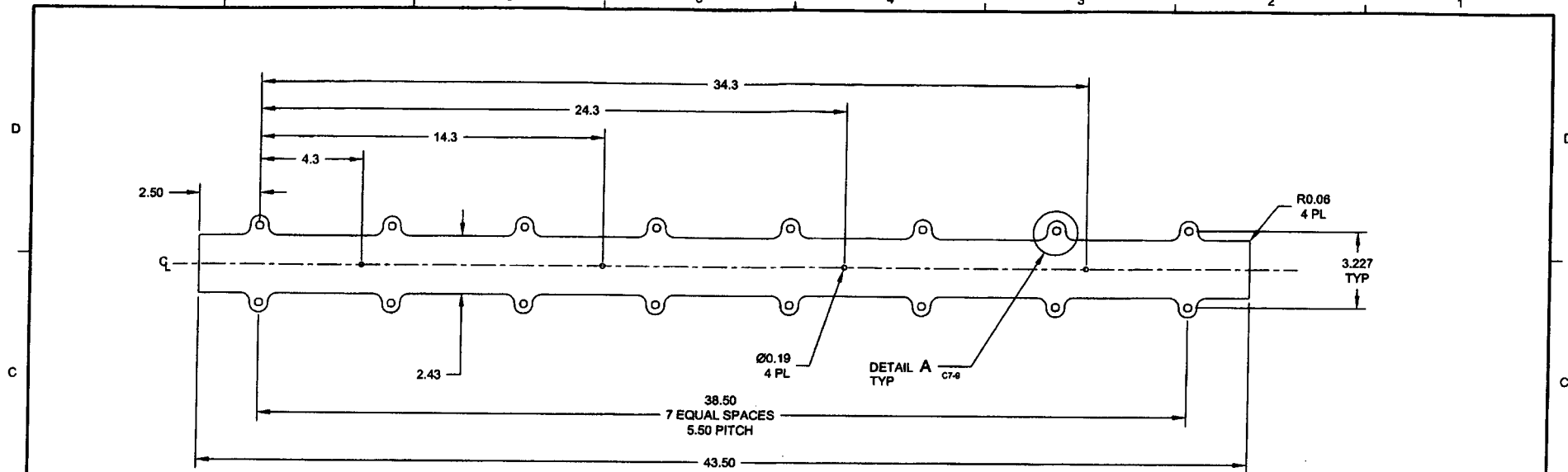


D4095-3 WELDING DETAIL

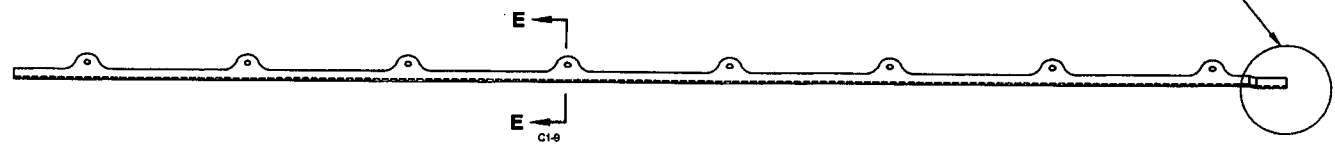
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8 7 6 5 4 3 2 1



D4095-5F FLAT PATTERN 1



D4095-5 BENDING DETAIL
(MAKE FROM D4095-5F)

D4095-5 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240
OR ASME SA240 REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5
- 9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

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2016-01-11

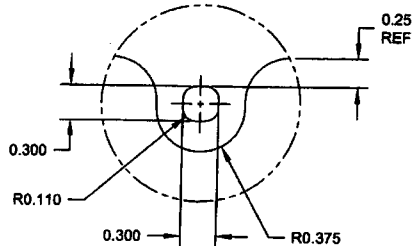
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8 7 6 5 4 3 2 1



9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

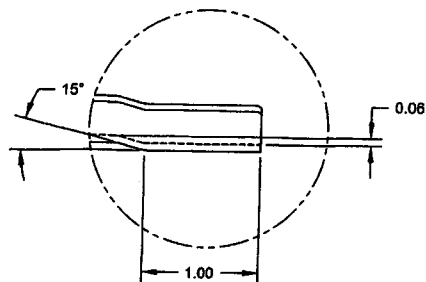
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DETAIL A: TAB DETAIL

SCALE 4X

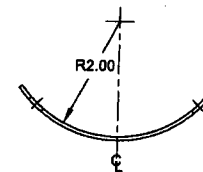
C3-3
C6-5
D3-7
D2-8



DETAIL B: JOGGLE DETAIL

SCALE 4X

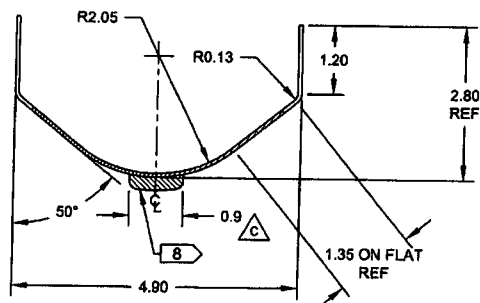
B2-4
B6-4
B3-6
B2-7



SECTION E-E

SCALE 2X

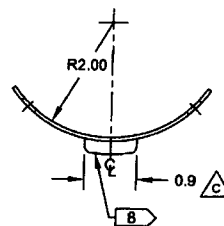
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SECTION C-C

SCALE 2X

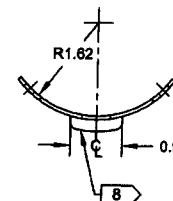
B6-4
B4-6



SECTION D-D

SCALE 2X

B4-4
B5-6



SECTION F-F

SCALE 2X

B5-8
B7-8

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